

Date: Thursday, 4/12/2007 8:46:28 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SUPPORT
Job Number	31736		
Estimate Number	10462		
P.O. Number	N/A	Part Number	D32782
This Issue	4/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3278 REV. B
First Issue	N/A	Project Number	N/A
Previous Run	31661B	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By	<u>JL</u> 07.04.12	Due Date	5/10/2007
Comment	Est:A 04.04.19 New issue KJ/JLM	Qty:	60
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
		Comment: Qty.: 0.2454 f(s)/Unit Total : 14.7231 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000)	 Batch: <u>M19295</u> <u>ML 07/02/20</u>
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long	<u>ML 07/02/20</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2	<u>J.F./J.L. 07/04/22</u> <u>60</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>J.F./J.L. 07/04/22</u> <u>60</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>M8</u> <u>07/04/25</u> <u>60</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:46:28 AM
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Drawing Name: SUPPORT

Job Number: 31736

Part Number: D32782

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



60x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/04/25

7.0 POWDER COATING

POWDER COATING



M103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

41

07-04-25 66

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

07/04/25

60

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PD

7/4/26 50 60

60

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

60

Job Completion



U 07/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31736
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.098	✓			
0.359	+/-0.005	.361"	✓			
.609 .615	+/-0.010	.614"	✓			
0.250	+/-0.010	.250"	✓			
1.480	+/-0.005	1.482"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.119	+0.005/-0.004	.123"	✓			
2.439	+/-0.010	2.441"	✓			
1.980	+/-0.010	1.983	✓			
R0.130	+/-0.010	R.130"	✓			
Ø0.257	+0.005/-0.000	Ø.259"	✓			
R0.375	+/-0.010	R.375"	✓			
0.875	+/-0.010	.877"	✓			
0.500	+/-0.010	.500"	✓			
R0.400	+/-0.010	R0.400"	✓			
1.720	+/-0.010	1.725"	✓			
R0.125	+/-0.010	R.125"	✓			
0.125	+/-0.010	.129"	✓			

Measured by:	J.F.	Audited by:	E.n	Prototype Approval:	N/A
Date:	07/04/22	Date:	07/04/22	Date:	N/A

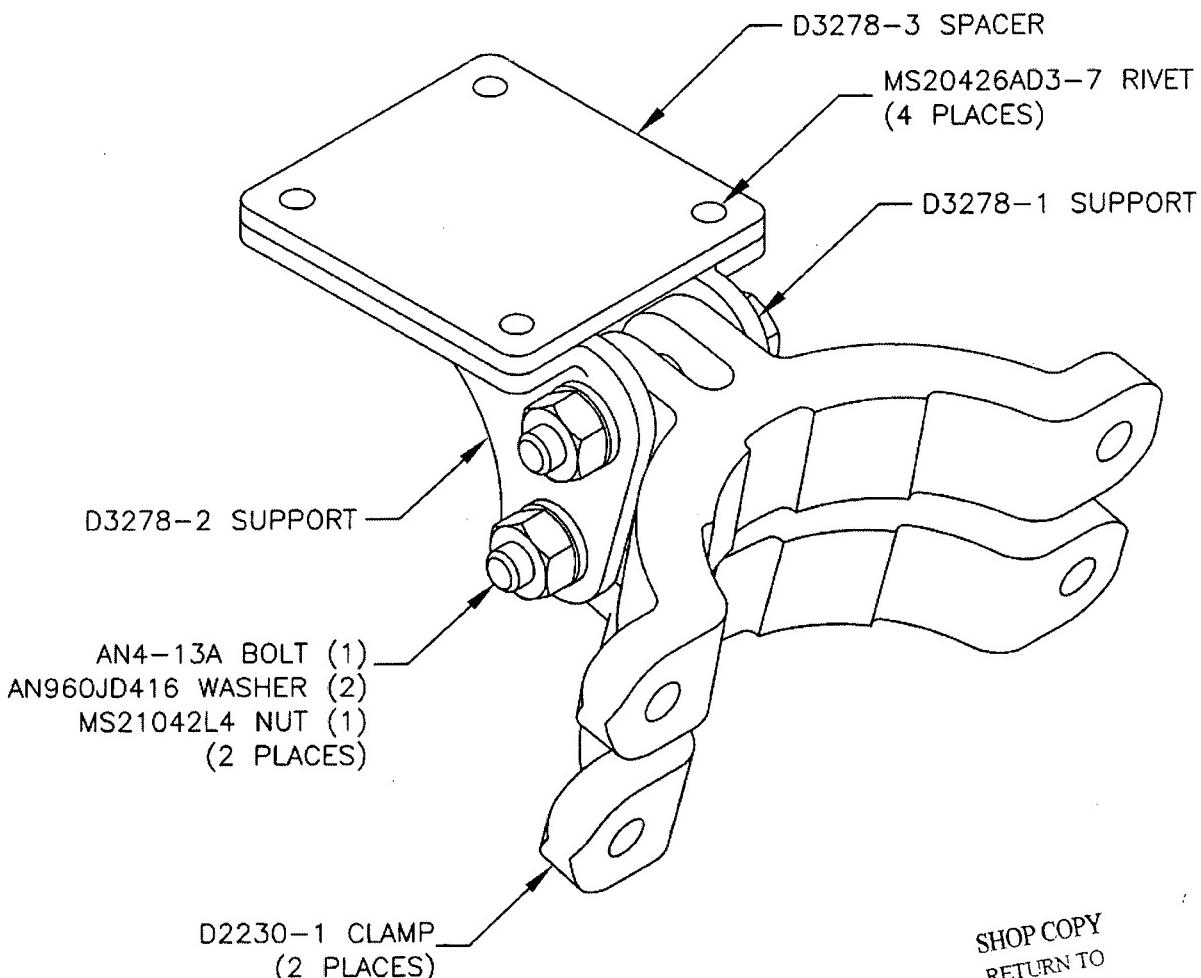
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04 - *[initials]*

D3278-041 SUPPORT ASSEMBLY



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WORK ORDER
NO. *31736*

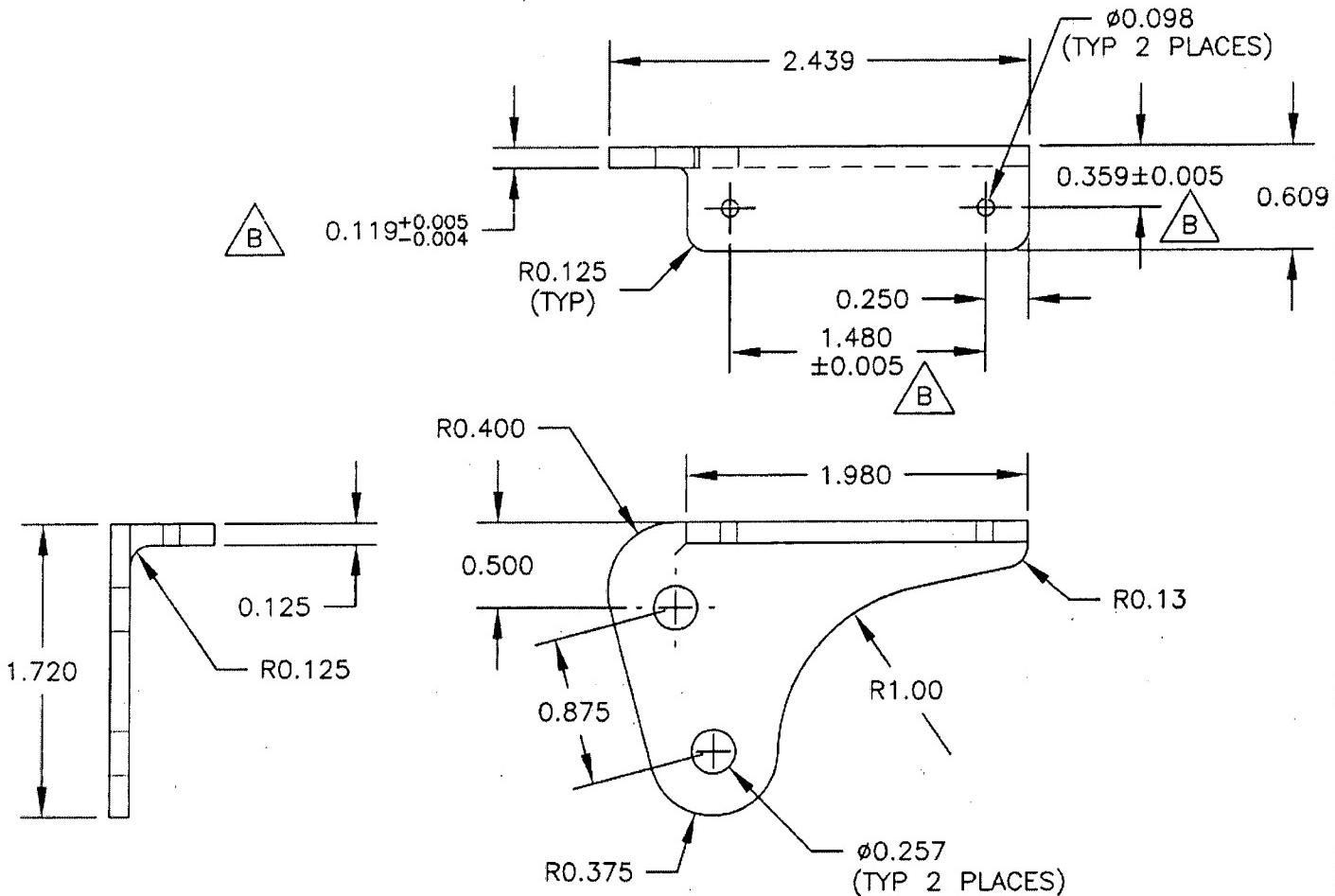
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-
A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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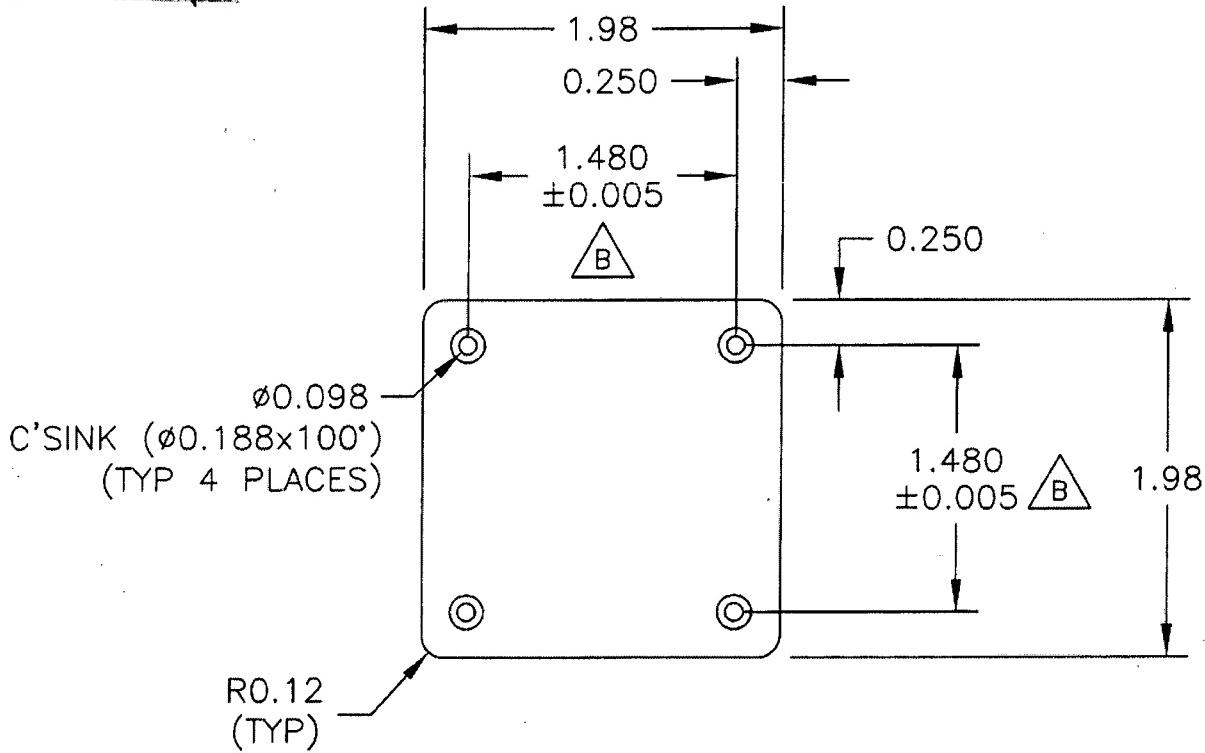
WORK ORDER
NO. 31736



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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 3 OF 3 SCALE 1:1

RELEASED

05.04.04 *[initials]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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